

Work Order ID 59847

Monday, June 14, 2010 2:31:39 PM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 6/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10-06-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D3838

Rev A

100



Large Fab

Large Fab

Memo

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

100



2- remove identification markings

100



3- deburr

100

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open
to finish size as per dwg D3838A/R ER316 S.S. Rod Batch: *111679*

100



5- c'sink hole as per dwg

100



6- grind weld flush where indicated on dwg D3838

100



7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *111679*

100



8- grind bushing weld flush as per dwg dwg D3838

100



9- deburr hole if necessary

*S40 10-06-18**2**PL 10-06-30*

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 06/14/10

②

-0412

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

② PD 10.07.01

130



Packaging

Packaging

Identify as per dwg & Stock Location: Basket

0.00

② PD 10.07.01

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Start Date: 6/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/01
MF
10-7-0

Picklist Print

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Page 1

Work Order ID: 59847



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/14/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1



Bushing

Manufactured

No

100

Each

16.0000



1

2

JL 10-06-30

Location	Loc Qty	Loc Code
WA	16	
54072	9	
58672	7	

B59644 → (2)

M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100

f

938.4760



1.0317

2.172

SAC 10-06-28

Location	Loc Qty	Loc Code
MAT	53.32232	
112398	0	
114482	53.32232	
WA	885.1537	
114520	885.1537	

2.172

8

7

6

5

4

3

2

1

D

D

C

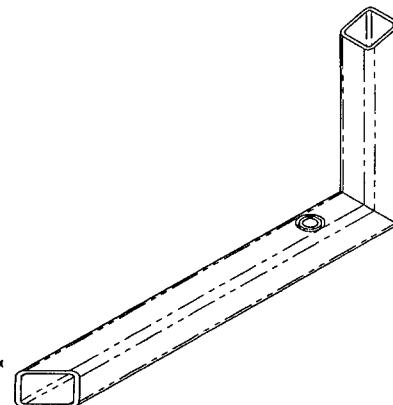
C

B

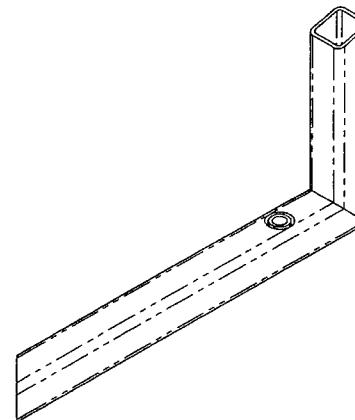
B

A

A



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 39817

pd 10-6-14

RELEASED
08/11/08 JMW

A	NEW ISSUE	MB	08.10.08
REV.		BY	DATE
DESIGN	<i>[initials]</i>	DART AEROSPACE LTD	
DRAWN	<i>[initials]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[initials]</i>	D3838	SHEET 1 OF 3
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	RIB ASSY (BASKET LID)	
DATE	08.10.08	NTS	

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8

7

6

5

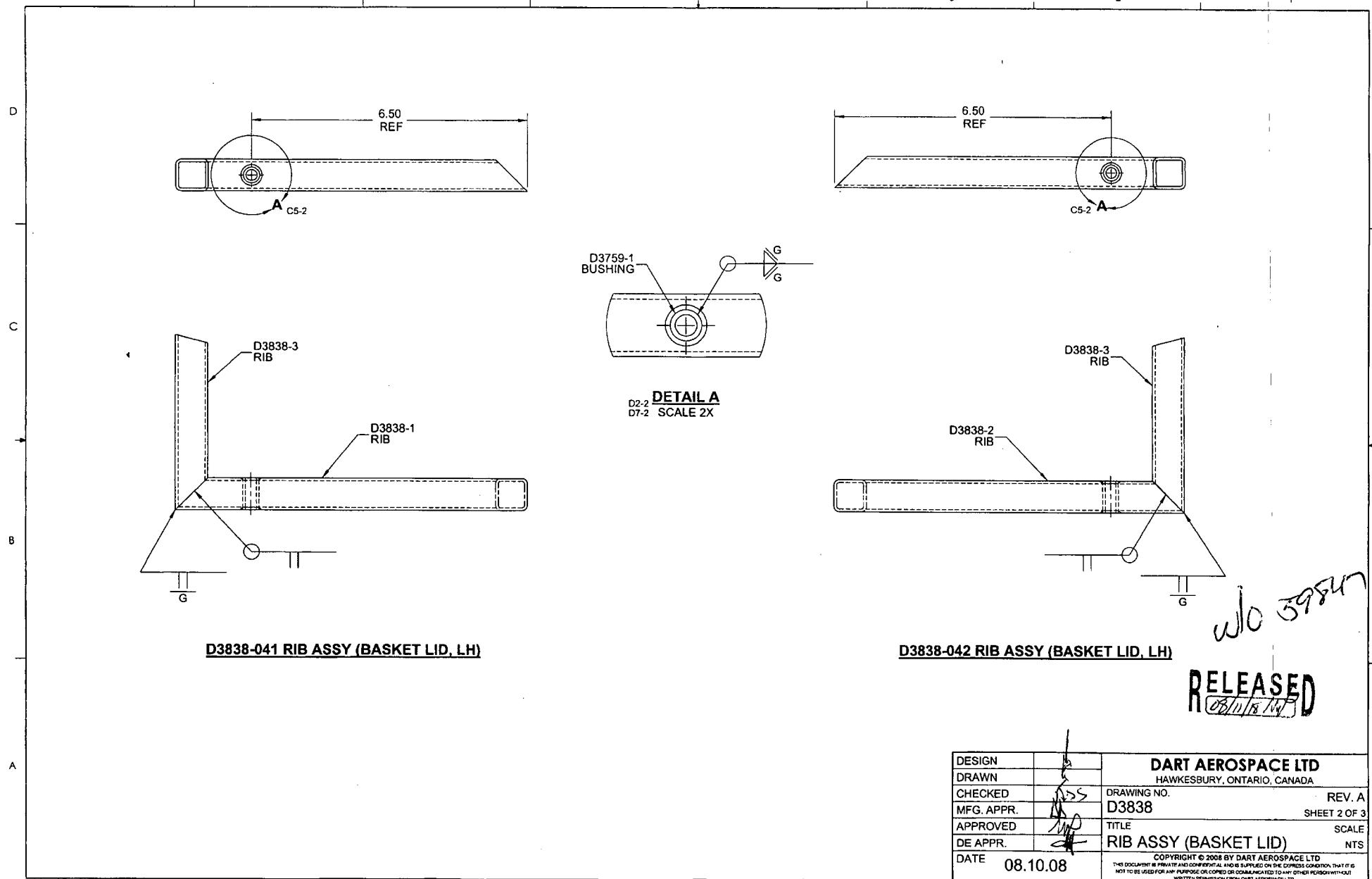
4

3

2

1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8

7

6

5

4

3

2

1

